

Date: Tuesday, 07/04/2009 10:18:14 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 46952		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 07/04/2009 S.O. No. :		Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 24/04/2009 Qty: 10 Um: Each		
Previous Run	: 46432					
Written By	:					
Checked & Approved By	: <u>JUL 09 04 07</u>					
Comment	: Est: 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	Saddle Billet
		<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>46412</u></p> <p style="text-align: right;">mwf 09/04/11</p>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>46952</u> Double check by: <u>mwf</u></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.</p> <p style="text-align: right;">mwf 09/04/11 JL 09/04/11</p> <p style="text-align: right;">PTO</p>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		<p>Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572</p> <p style="text-align: right;">mwf 09/04/11 JL 09/04/11</p>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: right;">JL 09/04/11</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 09/04/10
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46952</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/11	2.0	Machine bug and chiller tool went to low 2.c. Unexplained Machine Malfunction.	<u>Initial</u>	Scraped. No replace. qty 1	<u>mmf</u> <u>09/04/11</u>	<u>8/8</u> <u>09/04/14</u>	<u>Initial</u>	<u>Initial</u> <u>09/04/14</u>

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:18:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 46952

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09/04/14

⑨

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF

09-04-14

X9

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MF 110939

START TIME: 9:30

OVEN TEMPERATURE: 320

FINISH TIME: 10:00

MF 09-04-15

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⑨

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



FL 09/04/15

⑨

Comment: INSPECT POWDER COAT

09-04-15

X9

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5433

A 09-04-15

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/04/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	46952
Description: Saddle, Fwd Outboard			Part Number:	D2571
Inspection Dwg: D2571 Rev. E			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.439	.438			
B	1.745	1.755		1.750	1.750	1.748			
C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.750	1.750	1.748			
E	7.990	8.010		8.004	8.002	8.002			
F	0.490	0.510		.501	.501	.503			
G	0.257	0.262		.260	.258	.260			
H	0.375	0.380		.377	.377	.377			
I	0.490	0.510		.503	.503	.503			
J	1.174	1.184		1.175	1.175	1.180			
K	0.558	0.578		.570	.570	.570			
L	1.174	1.184		1.175	1.175	1.180			
M	1.490	1.500		1.497	1.493	1.495			
N	2.495	2.505		2.497	2.496	2.499			
O	3.869	3.879		3.872	3.871	3.874			
P	0.115	0.135		.123	.124	.126			
Q	0.115	0.135		.135	.135	.129			
R	0.240	0.260		.251	.251	.251			
S	0.115	0.135		.132	.131	.131			
T	0.178	0.198		.188	.188	.188			
U	2.940	2.980		2.958	2.955	2.957			
V	0.230	0.250		.240	.242	.239			
W	0.115	0.135		.130	.131	.123			
X	0.308	0.313		.310	.311	.311			
Y	0.760	0.765		.760	.760	.760			
Z	0.352	0.372		.368	.366	.364			
AA	0.470	0.530		.500	.500	.501			
AB	0.615	0.635		.625	.621	.623			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.250	.250	.250			
AE	1.375	1.395		1.391	1.390	1.392	1.387		
AF	0.115	0.135		.125	.130	.129			
AG	0.240	0.280		.265	.270	.264			
AH	0.240	0.260		.244	.246	.246			
AI	2.000	2.020		2.006	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033			

Accept/Reject

Measured by: *man*
Date: 09/04/12

Audited by: *BB*
Date: 09/04/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>BB</i>	<i>BB</i>

DART AEROSPACE LTD				Work Order:	148952
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.458	.440	.440		
B	1.745	1.755		1.746	1.747	1.750	1.750		
C	3.495	3.505		3.497	3.498	3.500	3.500		
D	1.745	1.755		1.747	1.747	1.750	1.750		
E	7.990	8.010		8.005	8.004	8.001	8.000		
F	0.490	0.510		.502	.510	.508	.500		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.377	.377	.376	.376		
I	0.490	0.510		.503	.503	.504	.503		
J	1.174	1.184		1.177	1.178	1.179	1.179		
K	0.558	0.578		.570	.571	.570	.570		
L	1.174	1.184		1.177	1.177	1.179	1.179		
M	1.490	1.500		1.494	1.494	1.495	1.495		
N	2.495	2.505		2.502	2.502	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.874	3.874		
P	0.115	0.135		.124	.125	.123	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.131	.129	.126	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.956	2.954	2.959	2.960		
V	0.230	0.250		.239	.238	.241	.242		
W	0.115	0.135		.128	.130	.124	.124		
X	0.308	0.313		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.626	.624	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.246	.245		
AE	1.375	1.395		1.387	1.390	1.391	1.389		
AF	0.115	0.135		.129	.130	.135	.135		
AG	0.240	0.280		.277	.272	.260	.260		
AH	0.240	0.260		.244	.245	.246	.246		
AI	2.000	2.020		2.005	2.005	2.006	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	/ 3.1	Audited by:	/ 88
Date:	/ 09/04/14	Date:	/ 09/04/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	9/11

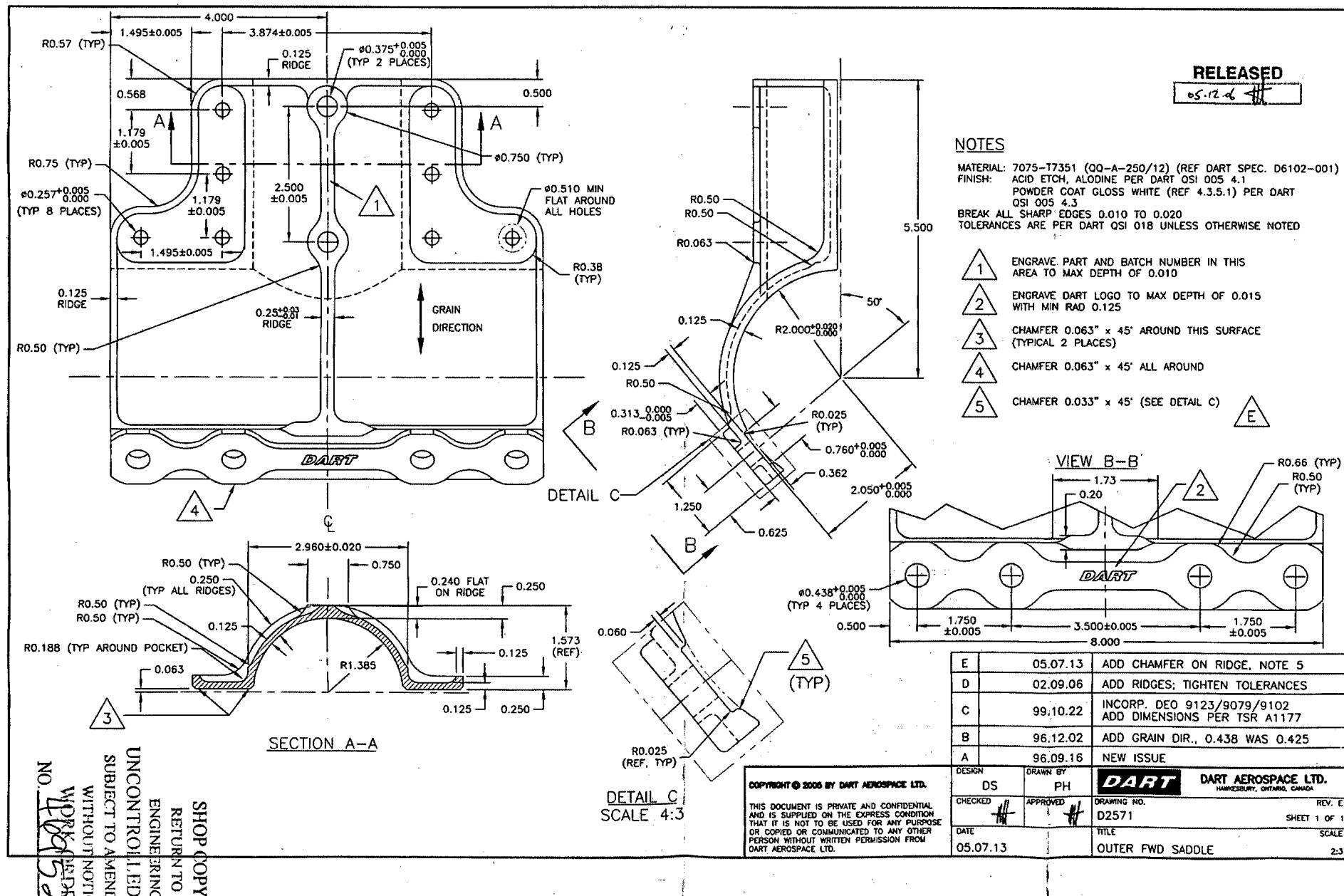
DART AEROSPACE LTD		Work Order: 116952
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				19	20	3	4			
A	0.438	0.443		.440	.440					
B	1.745	1.755		1.750	1.750					
C	3.495	3.505		3.500	3.500					
D	1.745	1.755		1.750	1.750					
E	7.990	8.010		8.000	8.001					
F	0.490	0.510		.504	.506					
G	0.257	0.262		.259	.259					
H	0.375	0.380		.376	.376					
I	0.490	0.510		.503	.504					
J	1.174	1.184		1.179	1.179					
K	0.558	0.578		.571	.570					
L	1.174	1.184		1.179	1.179					
M	1.490	1.500		1.495	1.495					
N	2.495	2.505		2.500	2.500					
O	3.869	3.879		3.874	3.874					
P	0.115	0.135		.123	.124					
Q	0.115	0.135		.135	.135					
R	0.240	0.260		.250	.250					
S	0.115	0.135		.129	.130					
T	0.178	0.198		.188	.188					
U	2.940	2.980		2.960	2.960					
V	0.230	0.250		.242	.244					
W	0.115	0.135		.126	.125					
X	0.308	0.313		.310	.310					
Y	0.760	0.765		.760	.760					
Z	0.352	0.372		.366	.368					
AA	0.470	0.530		.500	.500					
AB	0.615	0.635		.624	.625					
AC	0.053	0.073		.063	.063					
AD	0.240	0.260		.245	.248					
AE	1.375	1.395		1.390	1.388					
AF	0.115	0.135		.135	.135					
AG	0.240	0.280		.260	.260					
AH	0.240	0.260		.246	.251					
AI	2.000	2.020		2.002	2.000					
AJ	0.023	0.043		.033	.033					
Accept/Reject										

Measured by:	SL	Audited by:	SL
Date:	09/04/14	Date:	09/04/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SL



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